Work Order ID 115684

April-04-14 10:16:39 AM

115684

Item ID: D2600-1-160
Revision ID:
Item Name: Extrusion Round 3" 206
Start Date: 4/04/14 **Start Qty:** 80.00 *80*
Required Date: 4/04/14 **Req'd Qty:** 80.00 *80*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** 14-04-7 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2600	E								
100	PURCHASING	0.00							
100									
Purchasing	**Memo**	0.00							
Purchasing	Issue P/O: 23655								
	a) Extrude as per Dwg D2600 (160" long)								
	b) Material: 6061-T6								
	c) Material certification is required.								
	EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.								
	MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	**Memo**	0.00							
Packaging	Ensure material certification is attached								

14-4-07

4/15/16 (88)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D2600-1-160
Revision ID:
Item Name: Extrusion Round 3" 206
Start Date: 4/04/14 **Start Qty:** 80.00 *80*
Required Date: 4/04/14 **Req'd Qty:** 80.00 *80*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	~~QC6~~ Inspect dimensions to drawing	0.00	DAS 16 ~~9-89~~						
120 QC18			14 (ctr)			X88			PD →
QC	**Memo**	0.00							
Quality Control	Check Pull test per Dwg D2600 for compliance page attached Check hardness with Webster tester								
130	Identify as per dwg & Stock Location: LG Back Hall	0.00							
130						88		DMC 14-5-08	
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						MLJ	14-05-08		
QC	**Memo**	0.00							
Quality Control									

14-05 08

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only [X]

Work Order: 115684

Part No. DZ6001-160

NCR No. _____

DISPOSITION

Rework	
Scrap	
Use-as-is	
Suspected Unapproved	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube	
Machining		Small Fab	
Thermoforming		Finishing	
Large Fab		Composite	
Water Jet		Engineering	
Prod. Eng. Coor.		Quality	
Rec/Store/Packaging		Other	
Supplier			

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material					change step to QC 18 →			DAS 10 9-89		
Operator		14/05/06	# 120							14/05/06
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear

- [] Bending
- [] Centre Not Concentric
- [] Cracks
- [] Crimp/Kink/Ripple/Wave
- [] Cuffs
- [] Crushing
- [] Heat Treat
- [] Inspection Strip in Tube
- [] Marks/Chatter
- [] Turning Sequence
- [] Wave/Twist in Tube

General

- [] Bend
- [] BOM/Route
- [] Broken/Damage/Defect
- [] Burrs
- [] Contamination
- [] Countersink
- [] Cut Too Short
- [] Drawing
- [] Drill Holes
- [] Finish
- [] Fit/Function
- [] Folio/Program
- [] Grain
- [] Hardware
- [] Inspection Incomplete/Unqualified
- [] Instructions Incomplete/Unclear
- [] Misaligned/off center
- [] Mislabeled
- [] Misread
- [] Off-set
- [] Out of Calibration
- [] Out of Sequence
- [] Outside Dimensions
- [] Over/Under tolerance
- [] Part Incorrect
- [] Part Lost/Missing
- [] Part Moved
- [] Positioned Wrong
- [] Power Loss/Surge
- [] Pressure/Forced
- [] Set-up
- [] Temperature/Cure
- [] Weld
- [] Wrong Stock Pulled
- [] Other

Picklist Print

April-04-14 10:16:39 AM

Work Order ID: 115684 *115684*

Parent Item: D2600-1-160 *D2600-1-160*

Parent Item Name: Extrusion Round 3" 206

Start Date: 4/04/14 **Required Date:** 4/04/14

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP D: 02.09.05 Added DSK 066 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160P *D2600-1-160P* Extrusion Round 3" 206		Purchased	No			110	Each	0.0000	1 **	80			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

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☐ Marks/Chatter
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☐ Grain
☐ Hardware
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☐ Instructions Incomplete/Unclear
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☐ Mislabeled
☐ Misread
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☐ Out of Calibration
☐ Out of Sequence

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☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

SPECIFICATION CONTROL DRAWING

115684
MH04-7

D2600-X-XXX EXTRUSION

NOTES:

E 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)

7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.091 lb/in

8) NO TOOLING MARKS

9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:

- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121

10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:

- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122

11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:

- CARADON INDALEX DIE # MS-18871

12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:

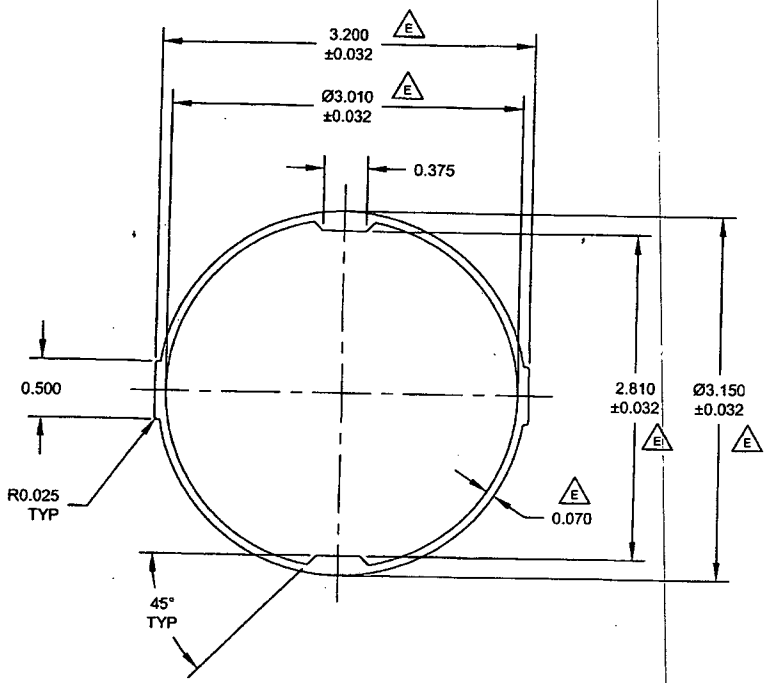
- CARADON INDALEX DIE # MS-18872

RELEASED
2012 -01- 11

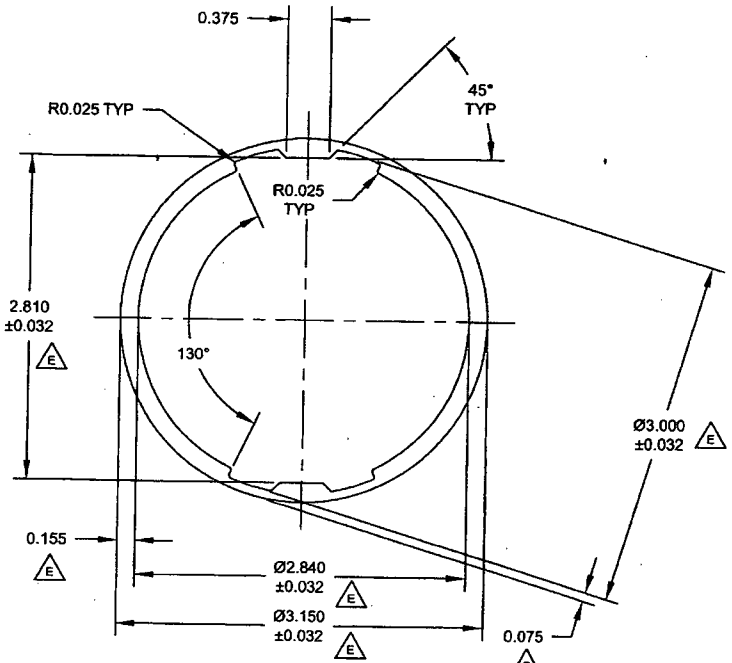
REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG; ALL DIMS & TOL. UPDATE TO MATCH MFG DIE DWGS; ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	A.S.S	DRAWING NO.	REV. E
MFG. APPR.		D2600	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	11.10.18		

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D2600-1 EXTRUSION

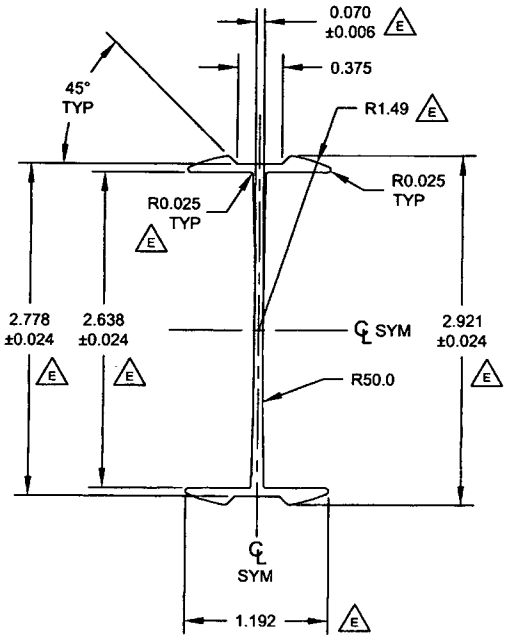


D2600-3 EXTRUSION

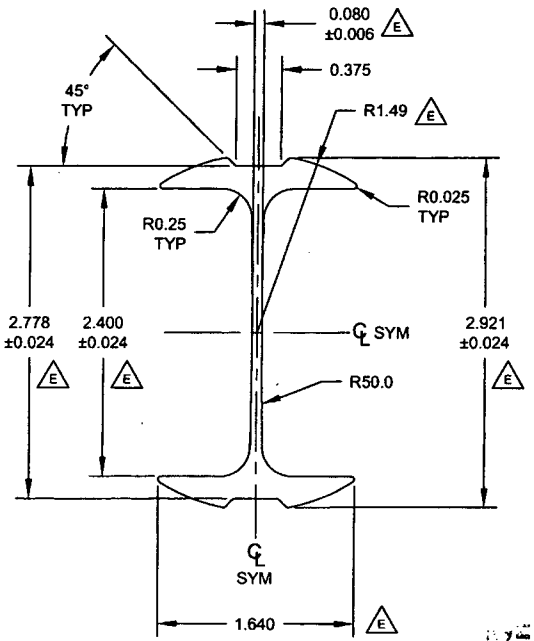
RELEASED
2012 -01- 10

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	AJS	DRAWING NO. REV. E D2600 SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE SCALE EXTRUSION NTS
DE APPR.		
DATE	11.10.18	

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D2600-5 EXTRUSION



D2600-7 EXTRUSION

RELEASED
2012 -01- 13

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2600	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EXTRUSION	NTS
DATE	11.10.18		

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23686

Purchase Order Date 4/7/2014
PO Print Date 4/10/2014

Order From : VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Brigitte Golden
Vendor Phone	905-427-6550	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	Yours ppd	**FOB**	Destination-Collect
Ship Acct:			

3	D2600-1-160P	Extrusion Round 3" 206	5/5/2014	80.00		$39.60	$3,167.65
			Yes	Each			
	AS PER DWG D2600 REV.E B115684 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS.		5/5/2014				

NC 88
4/4/16

Line Total: **$3,167.65**

4	71401-45	...	5/5/2014	1.00		$0.00	$0.00
			No				
	Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents		5/5/2014				

Line Total: **$0.00**

PO Total: **$7,458.16**

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explaination.

Change Nbr: 4 **Change Date:** 4/10/2014

signature aluminum CANADA INC

1850 Clements Road, Pickering Ontario, Canada L1W 3R8
Phone: (866) 587-5780 Fax: (905) 427-2207
Visit us at www.signaturealum.com

PACKING LIST

ACCT# 46024

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST DATE / DATE DU BODEREAU	PACKING LIST NUMBER / N' DE BODEREAL	SALES ORDER NUMBER / N' DE COM
05-05-14	014934	113847

REFER TO THESE NUMBERS ON ALL CORRESPONDANCE

REFEREZ-VOUS A CES NUMEROUS POUR TOUTE CORRESPONDANCE

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT	LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PP	PIC	WILRIDE	042		R. BLAIS

CUSTOMER ID / ID DU CLIENT	ORDER DATE / DE LA COM	CUSTOMER PO NUMBER / CLIENT PO Nombre	JOB / FICHIER	FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP. SERVICE CLIENTELE
46024	04/08/14	PO23686		G.ATTENBOROU	D1B
		BILL OF LADING NUMBER / NO. DE CONNAISSEMENT: 014934	CARRIER / TRANSPORTEUR: WILRIDE		

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO CUSTOMER PART NUMBER / NUMÉRO DE RÉFÉRENCE DU CLIENT	ALLOY & TEMPER / ALLIAGE & TEMPER LENGTH / LONGUEUR CUTTING TOLERANCE / Tolérance de coupe	FINISH DESCRIPTION / DESCRIPTION DE FINITION FABRICATION DESCRIPTION /DESCRIPTION DE FABRICATION SHIPPING TOLERANCE / EXPÉDITION TOLERANCE	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
003	1,068	LB		DAA-897121-1	6061 T6		2	1,171	1,127	LB	
	484	KG		D2600-1-160	160.0000 IN			531	511	KG	
	80	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			88	PC	
						834094 / 211476	1	653	631		49 PC
						834094 / 211477	1	518	496		39 PC

4	2,339	2,260	LB
	1,061	1,025	KG
		154	PC
TOTALS			

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS RD
PICKERING, ON L1W 3R8

Cert Date	Cert No.	Sales Order	Page
05/02/2014	5326435	113847	1
Cust PO	**B/L No**	**Lot**	**Date**
PO23686	014934	834094	05/05/14

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
003	DAA-897121-1	160" Mill 6061 T6	D2600-1-160
Gross Weight	1,171 LBS		
Net Qty	1,127 LBS	88 PCS	2 PKGS

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-08	

Mechanical Tests:

Tensile MPA / KSI	Yield MPA / KSI	% Elongation	Conductivity	HRE
299.3 / 43.4	271.8 / 39.4	10.1	N/A	95

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.61	0.21	0.20	0.03	0.88	0.06	0.02	0.02	0.01

S
14/05/14
(CAB a 14)

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical compositionfor the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

DART AEROSPACE LTD

Description: Extrusion Rough 3" 206.		**Work Order:** B115684
Inspection Drawing: D 2600	Rev: E	Part Number: D2600-1-160

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.700"	±.032	3.214"	✓		ED-6 Vern	
Ø 3.010"	±.032	~~3.014~~ 3.008"	✓		ED-6 Vern	
Ø 3.120"	±.032	3.146"	✓		ED-6 Vern	
2.810"	±.032	2.801"	✓		ED-6 Vern	
0.375"	±.010	0.375"	✓		ED-6 Vern	
0.500"	±.010	0.498"	✓		ED-6 Vern	
0.070"	±.010	0.073"	✓		ED-6 Vern.	

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
DAS 16 9-89	DAS 27 9-89	DAS 27 9-89	
Date 10/5/07	Date 14/5/7	Date 14/5/8	Date

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2600-1-160 PO / BATCH NO.: PO 23656 / B115684

DATE: May 6th, 2014

MATERIAL CERT REC'D: _____ THICKNESS ORDERED: _____

QUANTITY RECEIVED: _____ THICKNESS RECEIVED: _____

QUANTITY INSPECTED: _____ SHEET SIZE ORDERED: _____

QUANTITY REJECTED: _____ SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	(Y)	N	
CORRECT THICKNESS	(Y)	N	0.070 - 0.075 (see Attach inspect sheet)
PHOTO REQUIRED	Y	(N)	
CORRECT MATERIAL	Y	N	AMS-QQ-A-200/8
CORRECT REF # TO LINK CERT	Y	N	PO 23656.
CORRECT MATERIAL IDENTFICATION	Y	N	D2600-1-160
CORRECT M# ON THE MATERIAL	Y	N	B115684
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	(See Attached inspect sheet.

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: DAS 16	SIGNED OFF BY: _____
DATE: 9-89 14/05/07	DATE:

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

1- VERIFY STOCK TO DART PURCHASE ORDER
2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
5- VERIFY MATERIAL CERTS ARE CORECT TO THE DART PO INSTRUCTIONS
6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

1- VERIFY TO DART SUPPLIED DRAWING
2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVIED INTO DART
3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN **20pcs** FOR FULL INSPECTION
6- INSPECT ALL DIMS AS PER DRAWING REQUIRMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

1- VERIFY MATERIAL CERTS MATCH THE REQUIRMENTS ON THE DART DRAWINGS
2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVIED INTO DART
3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 b. OUTSIDE DIAMETETER HIGHEST/LOWEST BOTH ENDS
 c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
4- IDENTFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC CORRDINATOR BEFORE GOING FURTHER